IN THE CLAIMS:

All claims with their current status, inclusive of current amendments, are presented below.

1. (Amended hereby) An apparatus for the handling of a metal strip, wherein the apparatus includes a first coiler and a second coiler and a moveable roll, a strip path being defined between a first location and a second location, wherein a movement of ~~the~~ said movable roll ~~changing~~ can change the length of ~~the~~ said strip path, said coilers having a rotational angular position that changes with rotation thereof, said ~~the~~ apparatus further comprising ~~including~~ a measurer of the rotational angular position of at least one of ~~the~~ said coilers, and an actuator for ~~the~~ said moveable roll, ~~the~~ said actuator being provided with signals from ~~the~~ said measurer, wherein the position of said ~~the~~ moveable roll can be ~~being~~ defined, at least in part, as a function of the rotational angular position of at least one of ~~the~~ said coilers.

2. (Amended hereby) ~~An~~ The apparatus ~~according to~~ of claim 1, wherein said measurer comprises ~~in which one or both of the coilers are fitted with~~ at least one angular position ~~transducers~~ transducer, wherein said at least one angular position transducer can ~~to~~ measure the rotational angular position of at least one of said ~~the coiler or~~ coilers during coiling or uncoiling.

3. (Amended hereby) ~~An~~ The apparatus ~~according to~~ of claim 1, further comprising ~~in which the moveable roll is moved by~~ a roll position controller, wherein said roll position controller can control the movement of said moveable roll via said actuator, wherein said actuator comprises ~~such as~~ a hydraulic cylinder.

4. (Amended hereby) ~~An~~ The apparatus ~~according to~~ of claim 1, further comprising ~~in which~~ a moveable roll position transducer, wherein said moveable roll position transducer can be ~~is~~ used to measure the position of ~~the~~ said moveable roll.

5. (Amended hereby) ~~An~~ The apparatus ~~according to~~ of claim 1, further comprising ~~in which~~ an electronic controller and a servo valve, wherein said electronic controller and said servo valve can be ~~are~~ used to control the position of ~~the~~ said moveable roll according to a reference position.

6. (Amended hereby) ~~An~~ The apparatus ~~according to~~ of claim 1, further comprising ~~which includes~~ a control system ~~which controls the position of the rolls, the~~ , wherein said control system can control ~~controls~~ the position of said movable roll ~~the rolls~~ in response to information from ~~the~~ said measurer ~~or measurers~~.

7. (Amended hereby) ~~An~~ The apparatus ~~according to~~ of claim 1, ~~in which a~~ wherein said moveable roll is provided between one of said coilers ~~a coiler~~ and a rolling mill stand or other processing stage.

8. (Amended hereby) An apparatus for the coiling/uncoiling of a metal strip, comprising at least one coiler for coiling or uncoiling a metal strip thereabout, said apparatus providing a strip path for a metal strip to follow when a metal strip is operatively connected to said at least one coiler, said apparatus further comprising ~~characterised by having~~ a moveable roll in ~~the~~ said strip path, wherein a ~~such that~~ movement of ~~this~~ said moveable roll ~~changes~~ can change the length of ~~the~~ said strip path ~~to the coiler/uncoiler~~, said at least one coiler having a rotational angular position that changes with rotation thereof, said apparatus further comprising an angular position ~~and further characterized by having a~~ transducer, wherein said angular position tranducer can measure the rotational ~~measuring the~~ angular position of at least one of said at least one coiler, wherein ~~the coiler/uncoiler and further characterised in that~~ the position of ~~the~~ said moveable roll is automatically controlled as a function of the ~~coiler/uncoiler~~ rotational angular position of at least one of said at least one coiler.

9. (Amended hereby) The ~~An~~ apparatus ~~according to~~ of claim 8, further comprising a roll position controller, wherein said roll position controller can cause

movement of said ~~in which the~~ moveable roll ~~is moved by a roll position controller~~, wherein said roll position controller comprises ~~such as~~ a hydraulic cylinder.

10. (Amended hereby) The ~~An~~ apparatus ~~according to~~ of claim 8, further comprising ~~in which~~ a roll position transducer, wherein said roll position transducer can be ~~is~~ used to measure the position of ~~the~~ said roll.

11. (Amended hereby) The ~~An~~ apparatus ~~according to~~ of claim 8, further comprising ~~in which~~ an electronic controller and a servo valve, wherein said electronic controller and said servo valve can be ~~are~~ used to control the position of ~~the~~ said roll according to a reference position.

12. (Amended hereby) ~~An~~ The apparatus ~~according to~~ of claim 8, further comprising ~~which includes~~ a control system, wherein said control system can control ~~which controls~~ the position of ~~the~~ said movable roll ~~rolls, the control system controls the position of the rolls~~ in response to information from ~~the~~ said angular position transducer ~~measurer or measurers~~.

13. (Amended hereby) ~~An~~ The apparatus ~~according to~~ of claim 8, wherein said ~~in which a~~ moveable roll is provided between ~~a coiler~~ at least one of said at least one coiler and a rolling mill stand or other processing stage.

14. (Amended hereby) A method of handling a metal strip, ~~the method~~ comprising ~~providing a first coiler and a second coiler in a metal strip,~~ passing ~~the~~ a metal strip from a first coiler to a second coiler~~,~~ via a strip path ~~for the metal strip being~~ defined between a first location and a second location, contacting a moveable roll with ~~contacting~~ the metal strip between the first location and second location, ~~the method including~~ and measuring the rotational angular position of at least one of the coilers and moving the moveable roll so as to change the length of the strip path~~, the moveable roll being moved~~ as a function of the rotational angular position of at least one of the coilers.

15. (Amended hereby) The ~~A~~ method ~~according to~~ of claim 14, wherein the diameter of a coil formed by said metal strip about a coiler has an eccentricity and rotation of the coil causes tension variations in the metal strip due to the eccentricity, wherein the tension variations in the metal strip follow a tension variation pattern associated with the rotational angle of the coiler, said method further comprising moving the moveable roll ~~which the~~ in a roll movement pattern ~~of movement of the moveable roll as a function of the coiler/un coiler angle is chosen~~ to reduce the tension variations caused by rotation ~~eccentricity~~ of the coil ~~diameter~~.

16. (Amended hereby) The ~~A~~ method of claim 15, wherein ~~according to claim 4 characterised in that~~ the roll movement pattern ~~of movement of the moveable roll as a function of the angular position of the coiler/uncoiled~~ is calculated in advance of said passing step as a ~~the coiling operation~~ function of the anticipated eccentricity amplitude at varying rotational angles of the coil ~~and the geometry of the moveable roll~~.

17. (Amended hereby) The ~~A~~ method of ~~according to~~ claim ~~16~~ 30, wherein the ~~characterised in that the~~ anticipated amplitude of the coil diameter eccentricity is based on at least one of the group consisting of the ~~material type and/or~~ composition of the strip material, the strip ~~material~~ thickness, the strip ~~and/or the material~~ temperature, and ~~and/or~~ the number of laps of the strip on the coil.

18. (Amended hereby) The ~~A~~ method of ~~according to~~ claim 14, further comprising moving ~~in which~~ the movable roll in response to a signal, wherein the movable roll has a response time, and adding an offset ~~is added~~ to the measured ~~coiler/uncoiler~~ coiler rotational angular position in order to phase advance the signal to compensate for the response time of the moveable roll.

19. (Amended hereby) The ~~A~~ method of ~~according to~~ claim 18, wherein ~~in which~~ the offset is a function of the coiler ~~drum~~ rotation speed.

20. (Amended hereby) The ~~A~~ method of ~~according to~~ claim 14, further comprising using a ~~in which the the~~ control system ~~controls~~ to control the position of the roll ~~or rolls~~ in response to the rotational angle of the coiler ~~information from the measurer or measurers~~ in combination with further information~~, The further information being information about one or more of~~ selected from the group consisting of the thickness of the strip, the material forming the strip, the temperature of the strip, the number of passes of the strip through the rolling mill stand or other process stage, the number of laps of the strip on the coiler, the geometry of the strip length, the geometry of the moveable roll to the rolling mill stand or other process stage, the geometry of the moveable roll to ~~the~~ a further roll, the response time of the moveable roll, and the speed of rotation of the coiler.

21. (Amended hereby) The ~~A~~ method of ~~according to~~ claim 14, further comprising ~~in which~~ calculating an eccentricity amplitude for the system and obtaining a corrected eccentricity amplitude by correcting the calculated eccentricity amplitude ~~the method provides one or more methods by which the system the corrects the calculated eccentricity amplitude to give a corrected eccentricity amplitude~~.

22. (Amended hereby) The ~~A~~ method of ~~according to~~ claim 21, wherein ~~in which the method corrects~~ the calculated eccentricity amplitude is obtained by measuring the rotational speed of the coiler, wherein a decrease in speed of the coiler corresponds ~~corresponding~~ to the strip being applied over the location of eccentricity resulting in a corrected eccentricity amplitude which is greater than the calculated eccentricity amplitude and / or an increase in the rotational speed of the coiler at an angular position where the strip is applied over the location of the eccentricity ~~resulting~~ results in a corrected eccentricity amplitude which is lower than the calculated eccentricity amplitude.

23. (Amended hereby) The ~~A~~ method of ~~according to~~ claim 21, wherein ~~in which~~ the calculated eccentricity amplitude is corrected by measuring the tension in the strip and / or by measuring the load on the moveable roll, ~~the method provides that~~ wherein,

if the tension in the strip increases and / or the load on the roll increases as the strip is applied over the position of the eccentricity then the corrected eccentricity amplitude is greater than the calculated eccentricity amplitude, and / or ~~the method providing that~~ if the tension is reduced and / or the load on the roll is reduced as the strip is applied over the location of the eccentricity then the corrected eccentricity amplitude is less than the calculated eccentricity amplitude.

24. (Amended hereby) The ~~A~~ method of ~~according to~~ claim 21, wherein ~~in which~~ the calculated eccentricity amplitude is corrected by measuring the coil diameter and particularly the coil diameter for the eccentricity.

25. (New) The apparatus of claim 1, wherein at least one of said coilers comprises a drum with a slot, wherein said slot can receive an end of a metal strip, wherein said slot rotates with rotation of said drum to cause a metal strip having an end placed in said slot to coil about said drum or to uncoil from said drum depending on the direction of rotation, and wherein the rotational angular position of said at least one of said coilers is determined by the rotational position of said slot.

26. (New) The apparatus of claim 8, wherein at least one of said coilers comprises a drum with a slot, wherein said slot can receive an end of a metal strip, wherein said slot rotates with rotation of said drum to cause a metal strip having an end placed in said slot to coil about said drum or to uncoil from said drum depending on the direction of rotation, and wherein the rotational angular position of said at least one of said coilers is determined by the rotational position of said slot.

27. (New) The method of claim 14, wherein at least one of the coilers comprises a drum with a slot, one end of the metal strip is inserted in the slot, the slot rotates with rotation of the drum to cause the metal strip to coil about the drum or to uncoil from the drum depending on the direction of rotation, and wherein the rotational angular position of the coiler is determined by the rotational position of the slot, each revolution of the coiler drum causing a pattern of tension variations in the metal strip associated with the

eccentricity caused by the insertion of the end of the metal strip in the slot, wherein said method comprises moving the moveable roll in a moveable roll movement pattern to reduce the amplitude of the pattern of tension variations in the metal strip during rotation of the drum.

28. (New) A method of handling a metal strip, the method comprising passing a metal strip from a first coiler to a second coiler, wherein a strip path for the metal strip is defined between a first location and a second location, contacting the metal strip with a moveable roll between the first location and second location, the method further comprising measuring the angular position of at least one of the coilers and moving the moveable roll so as to change the length of the strip path, the moveable roll being moved as a function of the rotational angular position of at least one of the coilers, wherein the moveable roll is moved in response to a signal and the moveable roll has a response time, the method further comprising adding an offset to the measured coiler rotational angular position in order to phase advance the signal to compensate for the response time of the moveable roll.

29. (New) The method of claim 28, wherein the offset is a function of the coiler drum speed.

30. (New) The method of claim 16, wherein the metal strip is coiled on one of the coilers to form a coil, the coil has an anticipated amplitude of eccentricity and the pattern of movements of the moveable roll adjusts the strip path length to account for the anticipated amplitude of eccentricity of the coil.